

# Work Order ID 86763

\*86763\*

Page 1

July-06-12 2:19:35 PM

Item ID: D3500-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle

Start Date: 7/06/12

Start Qty: 40.00

\*40\*

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 40.00

\*40\*

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-07-12

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3500	C								

100

0.00

\*100\*

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 86763 Double check by: RT 1-Machine Step No 1  
per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step  
No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine  
Step No 3 per Folio FA641 and inspect p

FK 12/09/11

rd 12-9-13

PTO →

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

FK 12/09/11

rd 12-9-13

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

~~rd 12-9-11~~

SL 12-9-17

Dart Aerospace Ltd

W/O: 86763		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/09/20	#100	* Add note on w/o to have operator check the height of the Bore (x-tube and saddle) before Part is removed from Vises.					DAS 15 12/09/20

Part No: D3500-1 PAR #: \_\_\_\_\_ Fault Category: Machining NCR: Yes No DQA: OK Date: 12/09/27  
 Resolution: \_\_\_\_\_ Disposition: Use as is QA: N/C Closed: OK Date: 12/10/1

NCR: 12-835		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/9/10	100	Saddle wall thickness is up to 0.005" over tolerance (0.175). Qty (1) affected	DAS 12 12/9/11	Acceptable. BORE OK so no effect on fit.	DAS 12 12/9/11 F.K.	12.9.14	DAS 12 12/9/11	DAS 15 12/09/20
		RC Program is set too high.						

NOTE: Date & initial all entries

# Work Order ID 86763

\*86763\*

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July-06-12 2:19:35 PM

Item ID: D3500-1 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Saddle  
Start Date: 7/06/12 Start Qty: 40.00 \*40\* Cust Item ID:  
Required Date: 8/10/12 Req'd Qty: 40.00 \*40\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
*130*									
HandFinish	Memo	0.00							40X $\phi$ m.k. 12/09/17
Hand Finishing									
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
*140*									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:00 OVEN TEMPERATURE:								
	3200F FINISH TIME: 9:30								40X $\phi$ m.k. 12/09/18
150	QC3- Inspect Part Finish	0.00							
*150*									
QC	Memo	0.00							
Quality Control									40 $\phi$ 12-9-18.

M122878

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86763

\*86763\*

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July-06-12 2:19:35 PM

Item ID: D3500-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Saddle  
 Start Date: 7/06/12 Start Qty: 40.00 \*40\* Cust Item ID:  
 Required Date: 8/10/12 Req'd Qty: 40.00 \*40\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>428A</u>	0.00							
*160*									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
*170*									
QC	Memo	0.00							
Quality Control									

*h/SL 12/9/18*

*12/9/19*

*mk. 12-09-11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 2:19:35 PM

Page 1

Work Order ID: 86763

Parent Item: D3500-1

Parent Item Name: Saddle

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Perch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013 Saddle Billet		Manufactured	No			100	Each	28.0000	1	40			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT043	8	
60713	8	
MAT046	20	
85430	20	
87453		

20  
20

FK 12/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500		<b>Rev:</b> C	<b>Page 1 of 1</b>

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.498	.498	.498	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.590	1.590	1.589		
J	0.240	0.260		.252	.250	.247	.248		
K	0.490	0.510		.500	.500	.502	.502		
L	3.590	3.650		3.650	3.650	3.650	3.650		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.549	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.132	1.135	1.135	1.1345		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.635	.635	.635		
AD	0.240	0.260		.258	.253	.256	.256		
AE	1.810	1.830		1.822	1.825	1.820	1.820		
AF	0.240	0.260		.253	.253	.252	.252		
AG	0.140	0.160		.150	.149	.150	.150		
AH	0.140	0.160		.160	.152	.160	.160		
AI	0.140	0.160		.160	.158	.160	.160		
Accept/Reject				✓	✓	✓	✓		

Measured by:	F.K.
Date:	12/09/11

Audited by:	JL
Date:	12-9-11

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.498	.497	.499	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.588	1.5885	1.588		
J	0.240	0.260		.247	.249	.248	.250		
K	0.490	0.510		.500	.508	.500	.500		
L	3.590	3.650		3.650	3.650	3.650	3.650		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.997	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.548	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.134	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.254	.255	.254	.254		
AE	1.810	1.830		1.821	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.150	.149	.149	.149		
AH	0.140	0.160		.153	.154	.155	.152		
AI	0.140	0.160		.158	.156	.158	.155		
Accept/Reject									

<b>Measured by:</b>	FK-
<b>Date:</b>	12/09/12

<b>Audited by:</b>	SL
<b>Date:</b>	12.9.14

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

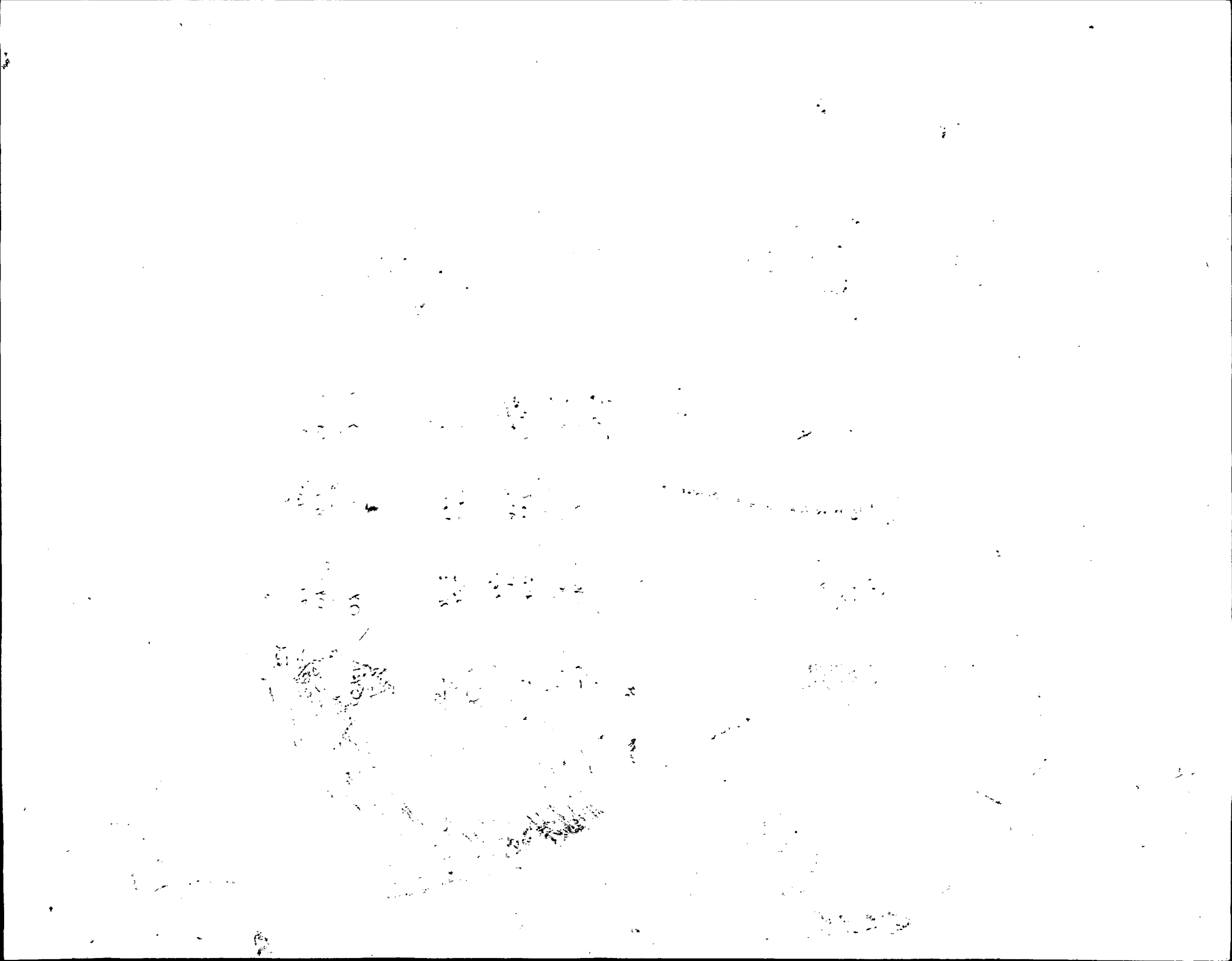
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	11	12		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.495		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589	1.588	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.501	.500	.500	.4980		
L	3.590	3.650		3.650	3.650	3.650	3.650		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.508		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.550	.545		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.1345	1.135	1.134	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.254	.255	.254	.253		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.250		
AG	0.140	0.160		.149	.150	.148	.148		
AH	0.140	0.160		.152	.152	.152	.152		
AI	0.140	0.160		.155	.155	.155	.157		
Accept/Reject									

<b>Measured by:</b>	FK
<b>Date:</b>	12/09/12

<b>Audited by:</b>	JL
<b>Date:</b>	12-9-12

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86763
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.495	.499	.499	.498		
H									
(Note: Dimension I is (.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	.240	0.260		.247	.247	.249	.248		
K	0.490	0.510		.500	.500	.499	.499		
L	3.590	3.650		3.62	3.62	3.62	3.62		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.544	.543	.543	.544		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.060	.060	.060		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.50	.50	.50	.50		
AC	.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.252	.251	.253	.253		
AE	1.810	1.830		1.822	1.820	1.820	1.821		
AF	0.240	0.260		.250	.249	.249	.250		
AG	0.140	0.160		.148	.148	.148	.149		
AH	0.140	0.160		.158	.157	.159	.159		
AI	0.140	0.160		.158	.158	.158	.159		
Accept/Reject									

Measured by: <i>RD</i>
Date: <i>12-9-13</i>

Audited by: <i>SL</i>
Date: <i>12-9-14</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>AA</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	17	18	19	20		
A	0.483	0.490		.485					
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.499	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.503	.503	.503	.503		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.545	.545	.545	.545		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.060	.060	.060		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.50	.50	.50	.50		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.254	.254	.254	.254		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.150	.149	.150	.149		
AH	0.140	0.160		.159	.159	.158	.158		
AI	0.140	0.160		.160	.159	.158	.157		
Accept/Reject									

Measured by: <i>2d</i>	Audited by: <i>SL</i>
Date: <i>12-9-13</i>	Date: <i>12-9-17</i>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>AA</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	16763
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		.485	.485	.455	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.181	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.499	.506	.501		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.585	1.588	1.581	1.589		
J	0.240	0.260		.247	.249	.249	.250		
K	0.490	0.510		.501	.501	.500	.500		
L	3.590	3.650		3.62	3.62	3.62	3.62		
M	0.315	0.322		.316	.311	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.546	.546	.547	.547		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.066	.060	.060		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.137	1.137	1.135		
AB	R.490	R.510		.50	.50	.50	.50		
AC	0.615	0.635		.628	.625	.625	.625		
AD	0.240	0.260		.255	.255	.255	.251		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.251	.250	.251	.250		
AG	0.140	0.160		.150	.149	.149	.149		
AH	0.140	0.160		.158	.158	.158	.160		
AI	0.140	0.160		.158	.157	.157	.158		
Accept/Reject									

Measured by:	EP
Date:	12.2.13

Audited by:	JL
Date:	12.9.17

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	25	26	27	28		
A	0.483	0.490		.484	.484	.484	.484		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.499		
H									
				(Note: Dimension I is 0.015" over flange)					
I	R1.575	R1.595		1.580	1.589	1.589	1.589		
J	0.240	0.260		.250	.249	.247	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	5.500	6.520		6.500	6.500	6.500	6.500		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.546	.546	.547	.546		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.060	.060	.060		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.136	1.136	1.137	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.255	.253	.255	.255		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.251	.250		
AG	0.140	0.160		.148	.147	.130	.149		
AH	0.140	0.160		.159	.159	.159	.158		
AI	0.140	0.160		.157	.157	.157	.158		
Accept/Reject									

Measured by:	RD
Date:	12-9-17

Audited by:	J
Date:	12-9-17

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	29	30	31	32		
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589	1.589	1.589		
J	0.240	0.260		.249	.248	.249	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.546	.546	.546	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.060	.060	.060	.060		
Y	0.100	0.120		.115	.105	.105	.105		
AA	R1.125	R1.145		1.136	1.136	1.135	1.1355		
AB	R.490	R.510		.50	.50	.50	.50		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.257	.257	.258	.257		
AE	1.810	1.830		1.812	1.820	1.810	1.820		
AF	0.240	0.260		.249	.250	.250	.252		
AG	0.140	0.160		.150	.148	.149	.151		
AH	0.140	0.160		.157	.160	.160	.160		
AI	0.140	0.160		.156	.150	.15	.159		
Accept/Reject									

Measured by: <u>28</u>	Audited by: <u>DL</u>
Date: <u>12-2-17</u> / <u>12/09/18</u>	Date: <u>12-9-17</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	86763
<b>Description: Saddle</b>		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg: D3500</b>	<b>Rev: C</b>	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	33	34	35	36		
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.589	1.589	1.589	1.590		
J	0.240	0.260		.248	.248	.249	.249		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.136		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.254	.254	.254	.253		
AE	1.810	1.830		1.820	1.820	1.821	1.820		
AF	0.240	0.260		.252	.252	.252	.252		
AG	0.140	0.160		.149	.149	.149	.149		
AH	0.140	0.160		.160	.159	.160	.160		
AI	0.140	0.160		.158	.160	.158	.158		
Accept/Reject									

Measured by: <u>FK</u>
Date: <u>12/09/15</u>

Audited by: <u>V</u>
Date: <u>12/9/15</u>

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	16763
<b>Description:</b> Saddle		<b>Part Number:</b>	D3500-1
<b>Inspection Dwg:</b> D3500	<b>Rev:</b> C	<b>Page 1 of 1</b>	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	37	38	39	40	By	Date
A	0.483	0.490		.485	.486	.485	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.377	.377	.377	.377		
F	0.490	0.510		.499	.500	.498	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.590	1.589	1.589	1.589		
J	0.240	0.260		.249	.249	.248	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.51		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.105	.105	.105	.105		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.252	.251	.252	.251		
AE	1.810	1.830		1.820	1.820	1.820	1.819		
AF	0.240	0.260		.252	.250	.251	.252		
AG	0.140	0.160		.149	.147	.148	.147		
AH	0.140	0.160		.160	.160	.158	.158		
AI	0.140	0.160		.158	.158	.159	.158		
Accept/Reject									

<b>Measured by:</b>	F.K.
<b>Date:</b>	12/09/15

<b>Audited by:</b>	JAH
<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

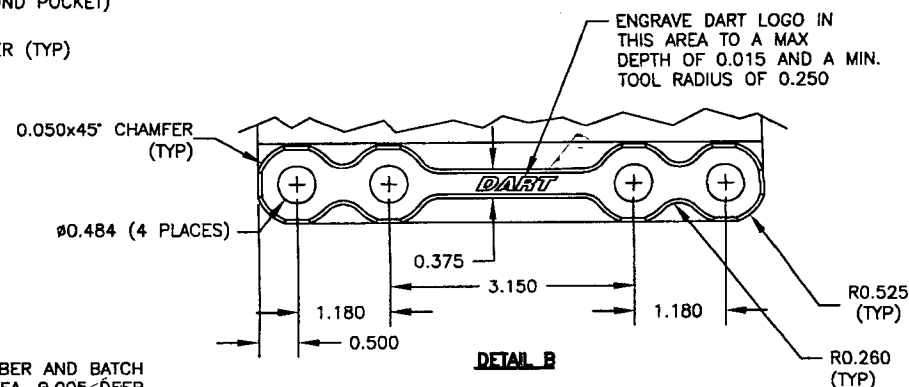
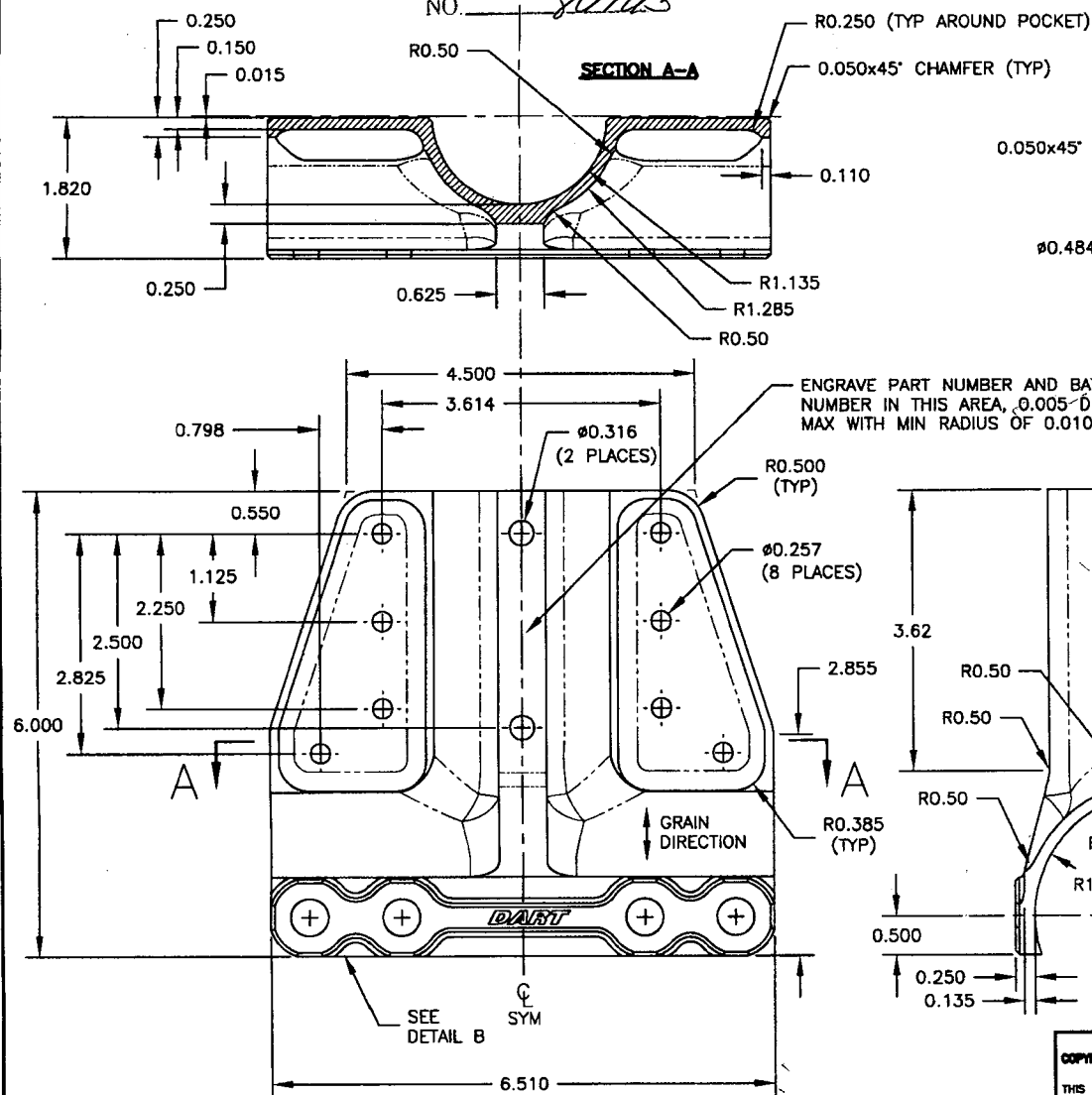
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WITHOUT NOTICE

WORK ORDER

NO.

86743

12079



### D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/B OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	97	DRAWN BY PH
CHECKED	4	APPROVED 4
DATE	06.06.30	TITLE SADDLE
DRAWING NO. D3500		REV. C
DART AEROSPACE LTD.		SHEET 1 OF 1
HARRISBURT, ONTARIO, CANADA		SCALE
		2:3

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries